

Date: Wednesday, 21/05/2008 1:04:34 PM
 User: Linda Lacelle

Process Sheet

OK

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : HEADREST ADAPTER
Job Number : 05004	
Estimate Number : 13333	
P.O. Number :	Part Number : D3773041
This Issue : 21/05/2008 S.O. No. :	Drawing Number : PROTO
Prsht Rev. : NC	Project Number :
First Issue : / / Type : R & D LG FAB	Drawing Revision : PROTO 08.05.21
Previous Run : 39372	Material :
Written By : <u>[Signature]</u>	Due Date : 28/05/2008 Qty: 4 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A 08.05-21 new issue DD verified by:ec	

FOR ENGINEERING USE ONLY

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D37731	Adapter
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Adapter
 batch: B39108 CPL 08.05.22

3.0	D37733	Leg
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Leg
 batch: B38989 CPL 08.05.22

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773
 ****take dowel pin out before welding****

2- weld as per dwg D3773 QSI004

304 S.S. Welding Rod Batch: M107051 CPL 08.05.22

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: HEADREST ADAPTER

Job Number: 05004

Part Number: D3773041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08.05.22 (4)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/05/22 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: _____

08.05.29

8.0

QC21

FINAL INSPECTION/W/O RELEASE



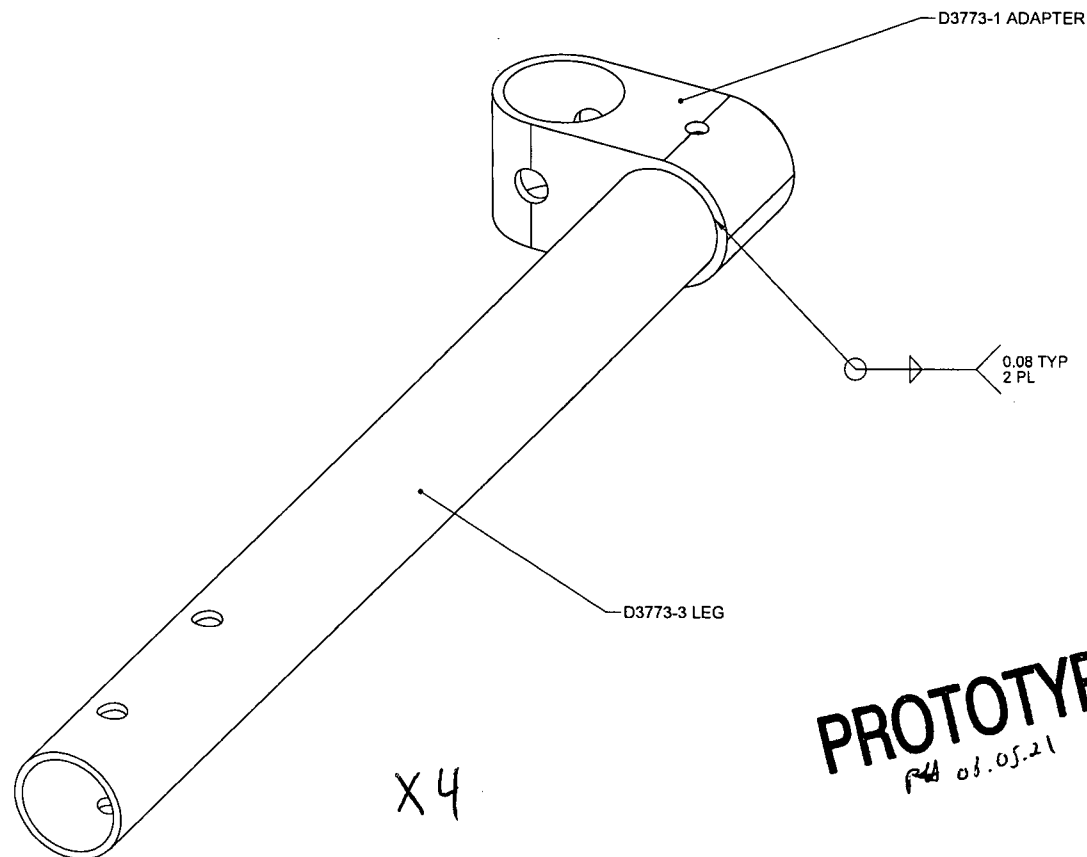
Comment: FINAL INSPECTION/W/O RELEASE

08.05.29 Prototype

Job Completion



u 8.6.11



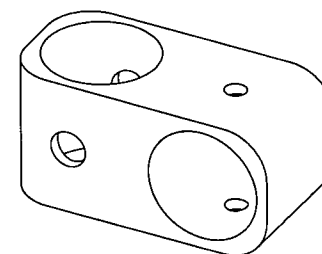
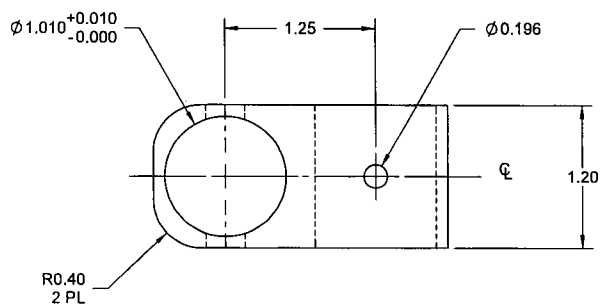
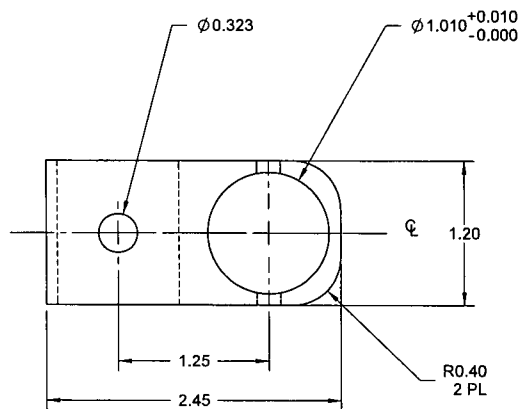
PROTOTYPE
 08.05.21

NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs
 D3773-3, 0.69 lbs
- 8) WELD: PER DART QSI 004

D3773-041 HEADREST ASSEMBLY

REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3773	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
DATE	08.05.05	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



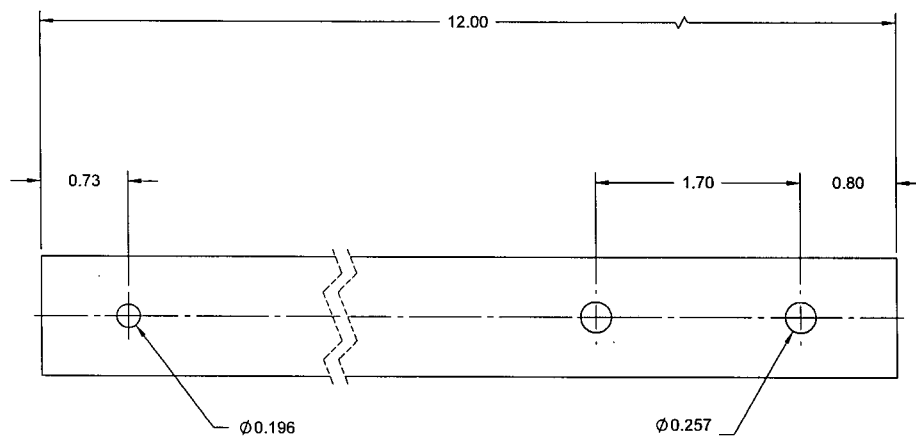
D3773-1 ADAPTER

PROTOTYPE
RH 08.05.21

NOTES:

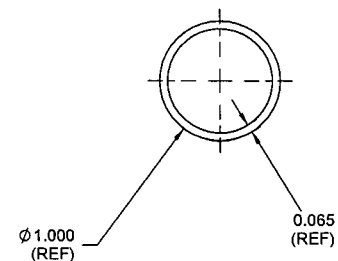
- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B1.20X1.20)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3773	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	1:1
DATE	08.05.05	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMERCIAL OR OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Ø0.257
2 PL

D3773-3 LEG



PROTOTYPE
for 08.05.21

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3773	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	1:1
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